

8. MAINTENANCE

8. PERIODIC INSPECTION

8-1 PERIODIC INSPECTION

For your periodic inspection, AW-3600 will give you a judgment that you should check which parts and when. "WRAPPING COUNTER" of MAINTENANCE MODE is prepared for this purpose.

[MAINTENANCE MODE/WRAPPER OPTIONS/WRAPPING COUNTER]

WRAPPING COUNTER (CONSUMABLE PARTS)					LABEL	EXIT
1 APPLICATOR SPONGE	5 CUTTER BLADE	9 COMMODITY ARM BRAKE	13 CUTTER GUIDE SOLENOID	17 CUTTER GUIDE PAD		
2 FILM FEED BELT<UPPER>	6 FEED ROLLER BRAKE		14 FILM SET SOLENOID	18 SPARE#1		
3 FILM FEED BELT<LOWER>	7 FILM FEED CLUTCH	11 CUTTER SOLENOID	15 FILM SET BRAKE	19 SPARE#2		
4 INFEEED BELT	8 STRETCH MOTOR BRAKE	12 CLAMP SOLENOID	16 ELEVATOR HEAD SPRING	20 SPARE#3		

WRAPPING COUNTER (INSPECTION PARTS)					LABEL	EXIT
1 FILM FEED BELT<UPPER>	5 L-R FOLDER *****	9 COMMODITY ARM BRAKE	13 CLAMP SOLENOID	17 SETTER BRAKE		
2 FILM FEED BELT<LOWER>	6 FEED ROLLER BRAKE	10 INFEEED SENSOR	14 CUTTER SOLENOID	18 CLAMP PRESSURE		
3 FRONT FOLDER DRIVING BELT	7 FEED CLUTCH	11 LABELING SENSOR	15 CUTTER GUIDE SOLENOID	19 FILM SET BRAKE		
4 DISCHARGE PUSHER BELT	8 STRETCH MOTOR BRAKE	12 TRAY WIDTH SENSOR	16 FILM SET SOLENOID	20 SPARE#4		

1. CONSUMABLE PARTS;

Consumable parts, in other words, is the regular spare parts that you should keep as regular inventory level after installation of the machine. You can figure out the proper quantity of each parts by checking "the count" in the display and if you count the number of the machine in your field. Therefore, for your regular spare parts, it is recommended to keep both "SPARE PARTS KIT" and "CONSUMABLE PARTS".

The replacement or inspection cycle of each parts is as follows;

[REPLACEMENT CYCLE OF THE CONSUMABLE PARTS] : Subject to 5000 packs/day Unit: 1,000

1. APPLICATOR SPONGE	1,800	10. SETTER BRAKE	5,400
2. FILM FEED BELT(UPPER)	2,700	11. CUTTER SOLENOID	5,400
3. FILM FEED BELT(LOWER)	2,700	12. CLAMP SOLENOID	5,400
4. INFEEED BELT	5,400	13. CUTTER GUIDE(sub) SOLENOID	5,400
5. CUTTER BLADE	5,400	14. FILM SET SOLENOID	5,400
6. FEED ROLLER BRAKE	5,400	15. FILM SET BRAKE	5,400
7. FILM FEED CLUTCH	5,400	16. ELEVATOR HEAD SPRING	2,700
8. STRETCH MOTOR BRAKE	5,400	17. CUTTER GUIDE PAD	1,800
9. COMMODITY ARM BRAKE	5,400		

[NOTE]

After replaced the parts, please clear the wrapping counter.

[INSPECTION CYCLE] : Subject to 5000 packs/day Unit: 1,000

1. FILM FEED BELT(UPPER)	900	11. LABELLING SENSOR	600
2. FILM FEED BELT(LOWER)	900	12. TRAY WIDTH SENSOR	600
3. FRONT FOLDER DRIVING BELT	1,800	13. (FILM FEED)CLAMP SOLENOID	600
4. DISCHARGE PUSHTER BELT	1,800	14. CUTTER SOLENOID	600
5. L-R FOLDER DRIVING BELT	1,800	15. CUTTER GUIDE SOLENOID	600
6. FEED ROLLER BRAKE	900	16. FILM SET SOLENOID	600
7. FEED CLUTCH	900	17. SETTER BRAKE	900
8. STRETCH MOTOR BRAKE	900	18. CLAMP PRESSURE	600
9. COMMODITY ARM BRAKE	900	19. FILM SET BRAKE	900
10. INFEEED SENSOR	600		

8-2. CHECK POINTS FOR THE INSPECTION PARTS

To check each parts, it will be done in WRAPPER MAINTENANCE MODE.

Please refer to § 5. ADJUSTMENT as well for proper tension and position.

[UNIT: 1000]

ITEM	CHECK POINTS	REMEDY
1. FILM FEED BELT(UPPER)	Tension and crack NB: Replace point at 2700 packs	Adjust tension or replace for crack
2. FILM FEED BELT(LOWER)	Tension and crack NB: Replace point at 2700 packs	- do -
3. FRONT FOLDER DRIVING BELT	Tension and crack	- do -
4. DISCHARGE PUSHTER BELT	Tension and crack	Adjust tension or replace for crack
5. L-R FOLDER DRIVING BELT	Tension and crack	- do -
6. FEED ROLLER BRAKE	<ul style="list-style-type: none"> Slipping by visual check in operation mode Gap 0.4mm at maximum Replace point at 5400 packs 	
7. FEED CLUTCH	- do - Except gap 0.2mm at maximum	
8. STRETCH MOTOR BRAKE	- do - Except gap 0.4mm at maximum	
9. COMMODITY ARM BRAKE	- do -	
10. INFEED SENSOR	• Check ON/OFF	
11. LABELLING SENSOR	• Check ON/OFF	
12. TRAY WIDTH SENSOR	<ul style="list-style-type: none"> Sensitivity Vcc (5.1V) at logic board 	• Adjust
13. (FILM FEED)CLAMP SOLENOID	<ul style="list-style-type: none"> Movement/Stroke Replace point at 5400 packs 	
14. CUTTER SOLENOID	<ul style="list-style-type: none"> Movement/Stroke Replace point at 5400 packs 	
15. CUTTER GUIDE SOLENOID	<ul style="list-style-type: none"> Movement/Stroke Replace point at 5400 packs 	
16. FILM SET SOLENOID	<ul style="list-style-type: none"> Movement/Stroke Replace point at 5400 packs 	
17. SETTER BRAKE	<ul style="list-style-type: none"> Slipping by visual check in operation mode Gap 0.4mm at maximum Replace point at 5400 packs 	

18. CLAMP PRESSURE	<ul style="list-style-type: none"> • Spring tension should be all 5 for standard. 	
19. FILM SET BRAKE	<ul style="list-style-type: none"> • Slipping • Gap 0.4mm at maximum • Replace point at 5400 packs 	

[NOTE]

Brake and clutch are adjustment-free. The gap in the column is at maximum and normally it is smaller at initial stage. If you could find that the gap is over maximum, please remove a shim inside. You may keep using only if the gap is smaller than the maximum after remove a shim.

We would like to inform you that there is a new silicon grease available for AW-3600. This is harder and more effective than the previous one informed in the Technical flash.

We recommend you to grease every about 600,000 packs. The following is the indication for greasing period.

In case of 3500 packs / day → Grease every 6 month

In case of 5000 packs / day → Grease every 4 month

In case of 7000 Packs / day → Grease every 3 month

* There is no change how to grease it on the film feed clamp. Please refer to the attached Technical Flash AW36/97/012

[Parts information]

Parts Name	Parts Code	Unit Price
Shinetsu Silicon Grease G30H	* TSN/98/022	

* For ordering, please write down this service news number for parts code.

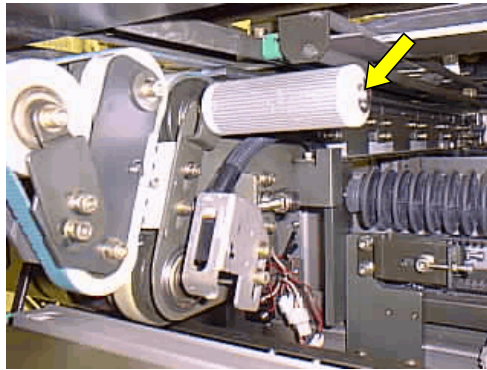
GREASE INFORMATION

We can provide greases for using AW-3600AT as follows.

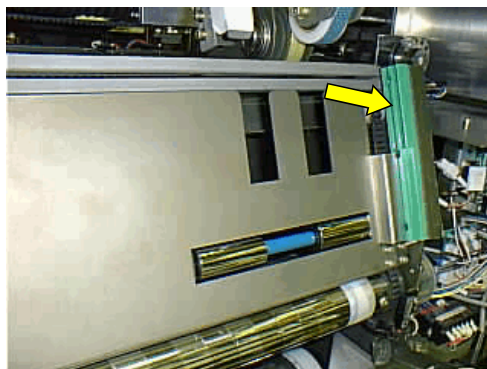
No.	Name	Type	Code Number	
#1	KF-96-50CS	OIL	99240A	
#2	KF-961-1000CS	OIL	99240B	
#3	SILICON GREASE KS-61	GREASE	99240C	
#4	SILICON GREASE G-30H	GREASE	98053	
#5	FM GREASE SPLAY	GREASE	98442	
#6	DUPLEX EP NO2	GREASE	98239G	

GREASEING POINT**#1. KF-96-50CS**

- Film guide roller of the Film feed block
If this grease is put not enough, film feed problem will happen.

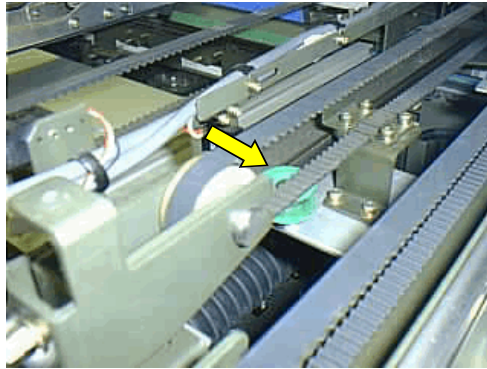
**#2. KF-961-1, 000CS**

- Green guide of the Setter block
If this oil is put not enough, Film setter plate will not move smoothly.



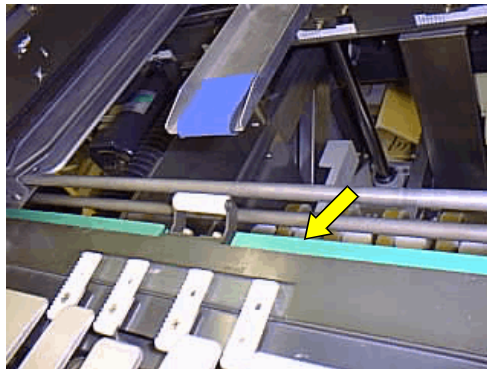
- Pulley of the Rear folder

If this oil is put not enough, Rear folder will not move smoothly.



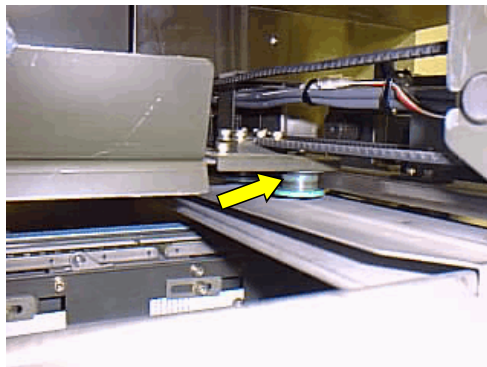
- Green guide of the Side folder

If this oil is put not enough, Side folder will not move smoothly.



- Pulley of the Discharge pusher

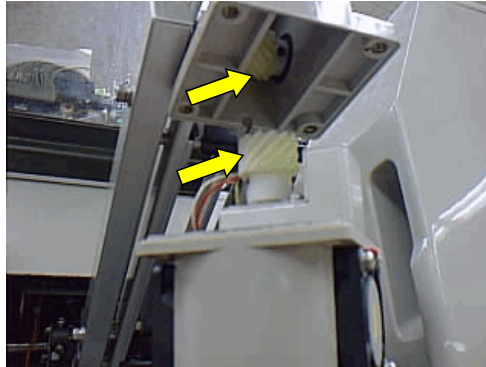
If this oil is put not enough, Discharge pusher will not move smoothly.



#3. SILICON GREASE KS-61

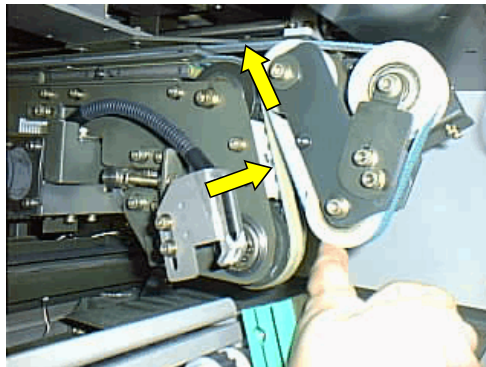
- Plastic gear inside of the Applicator

If this grease is put not enough, Applicator will not rotate smoothly or gears will wear out.

**#4. SILICON GREASE G-30H**

- Back side of the upper and lower film feed belt

If grease is put not enough, film feed will not center, noise will happen from film feed conveyor.

**#5. FM GREASE SPLAY**

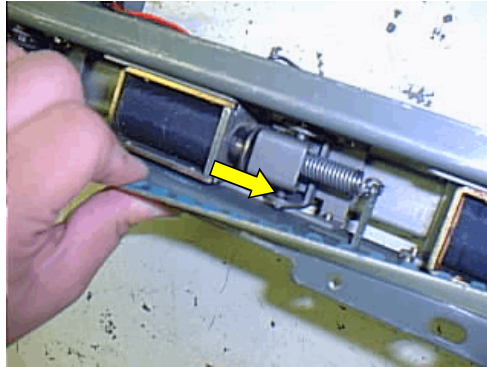
- Felt of the cutter clamp

If this oil is put not enough, Cutter will rust and Cutter can not cut film properly.

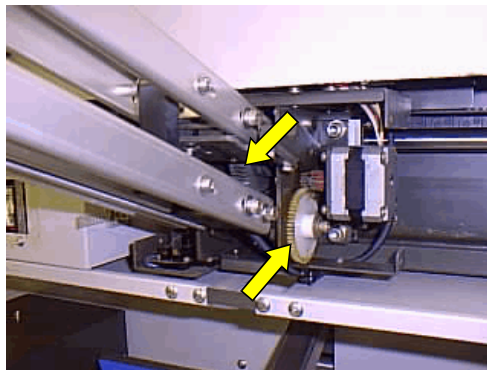


#6. DUPLEX EP NO2

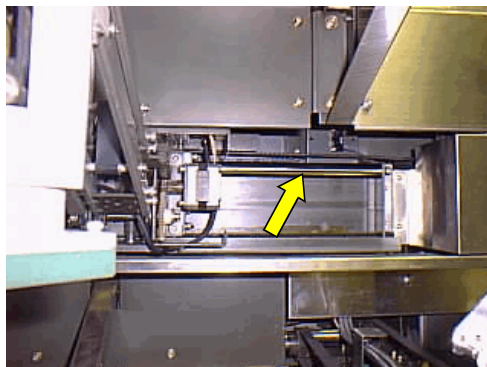
- Pin to hook spring for the film clamp of the film feed conveyor
If this grease is put not enough, Film feed will be not good.



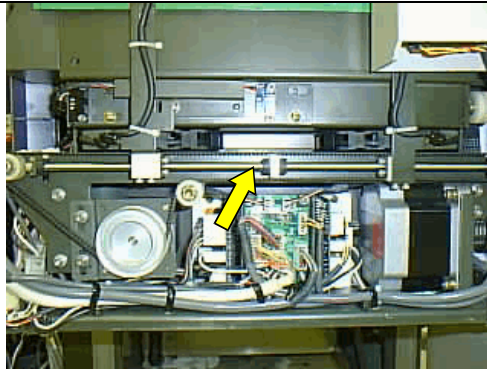
- Gear for up and down and rotate movement of the applicator
If this grease is put not enough, Applicator will not rotate smoothly.



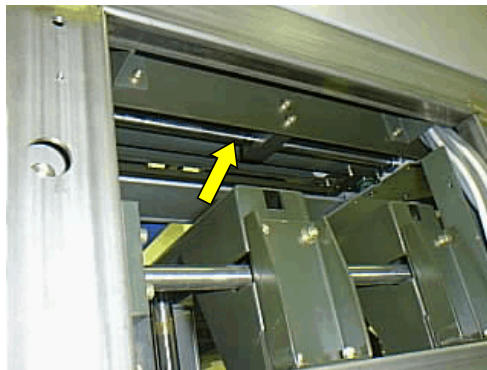
- Shaft for right and left movement of the applicator
If this grease is put not enough, Applicator movement will not be smoothly.



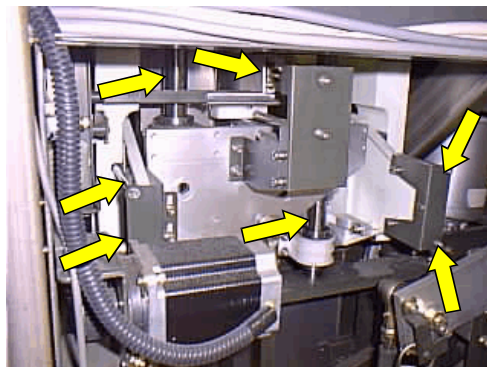
- Shaft for the Tray width sensor movement
If this grease is put not enough, Sensor motor movement will not be smoothly.



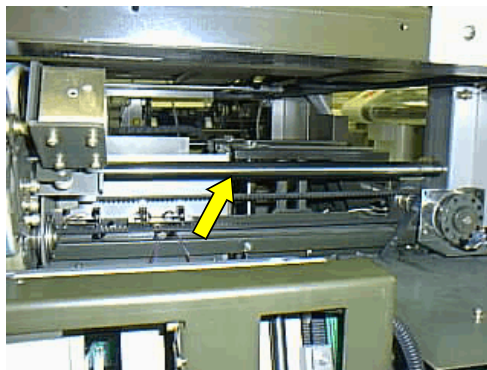
- Shaft for the Side folders
If this grease is put not enough, Side folder movement will not be smoothly.



- Shaft for the Elevator movement
If this grease is put not enough, Elevator movement will not be smoothly.



- Shaft for the stretch movement of the Film feed conveyor
If this grease is put not enough, film stretch movement will not be smoothly.



- Main motor Cam and Cam follower

If this grease is put not enough, Cam movement will not be smoothly.

